

# Work Order ID 66902

Wednesday, March 02, 2011 1:46:40 PM



Page 1

Item ID: D4191-1	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Housing				
Start Date: 3/2/2011	Start Qty: 2.00		Cust Item ID:	
Required Date: 3/25/2011	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/03/02</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4191	<u>PA+ PA6</u>								

100  
 BAND SAW 0.00  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut Blank to 4.5" SL 11/03/23  
 Batch: M114952 (2)

110  
 HAAS CNC VERTICAL MACHINING #1 0.00  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 1-Machine per folio FA987  
 DWG REV: PA6  
 FOLIO REV: AA  
 DRILL & TAP AS PER DWG  
 DRILL LOCK WIRE HOLES  
 2- deburr rough edges



MATERIAL CERTIFICATION  
 REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66902**

Wednesday, March 02, 2011 1:46:40 PM



Page 2

Item ID: D4191-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Housing

Start Date: 3/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B.A 11/03/23

2

Ø

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

J.M 11.03.23

2

Ø

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 Ø m-L 11/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## [REDACTED]

Page 3

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Author's address:** Department of Psychology, University of California, San Diego, La Jolla, CA 92037, USA.  
E-mail: jacob@ucsd.edu

**Customer:**

**Reference:**

Run Start

**Stop**

**Insp.  
Stamp**

0.00

[illegible]

QC

## Memo

0.00

### Quality Control

Identify as per dwg & Stock Location: FRNLY/EX 0.00

[illegible]

### Packaging

## Packaging

## Memo

0.00

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

RD 2334

34  
11-07-18  
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE;** Date & initial all entries

# Picklist Print

Page 1

Wednesday, March 02, 2011 1:46:16 PM

Work Order ID: 66902



Parent Item: D4191-1



Parent Item Name: Housing

Start Date: 3/2/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	51.9007	0.375	0.789474			



6061-T6 Bar 1.00 x 4.00

SL 11/03/23

Location

Loc Qty

Loc Code

MAT

12

107221

0

116808

12

MAT03

39.9007

107221

38.8685

114352

1.0322

.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

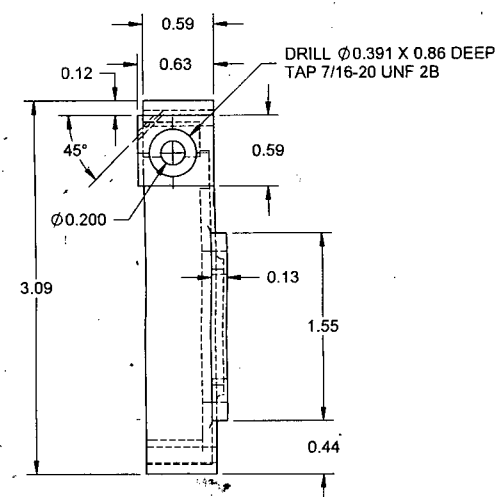
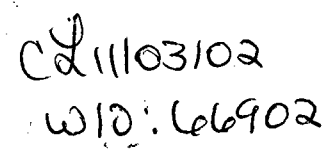
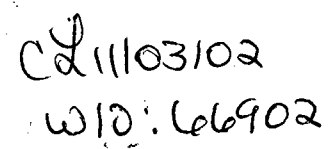
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





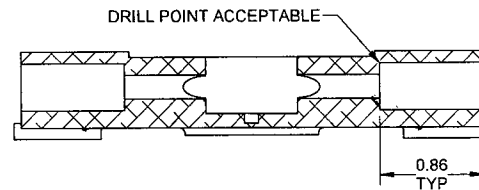
1) MATERIAL: 8061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8  
OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS-QQ-A-200/8  
OR AMS 4160  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.31 lbs

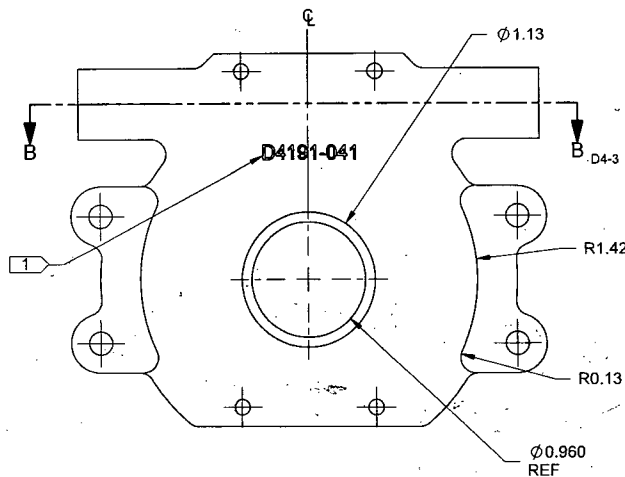
# PRELIMINARY ISSUE

10.11.17

DESIGN	<del>15</del>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4191</b>  TITLE <b>CONTROL BOX</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. PA
DRAWN	<del>15</del>		SHEET 2 OF 1
CHECKED	<del>15</del>		SCALE
MFG. APPR.	<del>15</del>		NT
APPROVED	<del>15</del>		
DE APPR.	<del>15</del>		
DATE	10.11.17		



**SECTION B-B** C6-3



**D4191-1 HOUSING**

**PRELIMINARY ISSUE**

10.11.17

NOTES:  
1) ENGRAVE P/N IN LOCATION SHOWN PER QSI 044 6.3

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		D4191	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		CONTROL BOX	NTS
DATE	10.11.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 66902
Description: HOUSING		Part Number: D4191-1
Inspection Dwg: D4191 Rev: PA6		Page 1 of 3

### FIRST ARTICLE INSPECTION CHECKLIST

☒

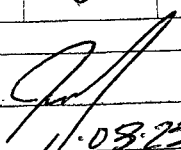
First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.72	+/- .030	0.722	✓		Vern	GA-01
2.55	+/- .030	2.547	✓		"	"
1.61	+/- .030	1.615	✓		"	"
Ø 1.13	+/- .030	Ø 1.125	✓		"	"
0.11	+/- .030	0.100	✓		"	"
3.87	+/- .030	3.873	✓		"	"
0.90	<del>+/- .030</del> +0.001/-0.001	0.900	✓		"	"
Ø 0.050	+0.001/-0.001	Ø 0.053	✓		"	"
0.34	+/- .030	0.336	✓		"	"
0.47	+/- .030	0.470	✓		D-6	GA-08
0.43	+/- .030	0.434	✓		Vern	GA-01
0.08	+/- .030	0.077	✓		H-6	31006
0.09	+/- .030	0.090	✓		D-6	GA-08
0.10	+/- .030	0.095	✓		Mic	GA-03
0.08	+/- .030	0.077	✓		H-6	31006
R0.015	+/- .010	R0.015	✓		R-6	ref.
0.285	+/- .010	0.285	✓		Vern	GA-01
R0.13	+/- .030	R0.125	✓		R-6	ref.
R0.06	+/- .030	R0.063	✓		"	"
0.78	+/- .030	0.777	✓		Vern	GA-01
1.130	+/- .010	1.130	✓		"	"
R0.06	+/- .030	R0.063	✓		R-6	ref.
R0.13	+/- .030	R0.125	✓		"	"

Measured by: K.A
Date: 11/03/23

Audited by: 
Date: 11-03-23

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

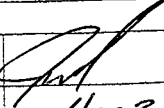
DART AEROSPACE LTD		Work Order: 66902
Description: HOUSING		Part Number: D4191-1
Inspection Dwg: D4191 Rev: PAG		Page 2 of 3

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.060	+/- .010	1.060	✓		Vern	GA-01
1.55	+/- .030	1.555	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
ø0.130	+ .005 / - .001	ø0.134	✓		Vern	GA-01
1.75	+/- .030	1.750	✓		H-6	31006
0.57	+/- .030	0.566	✓		"	"
ø0.960	+ .0005 / - .000	ø0.9602	✓		Vern/Mic	GA-03
ø1.25	+ .012 / - .001	ø1.252	✓		Vern	GA-01
R0.13	+/- .030	R0.125	✓		R-6	ref.
R0.13	+/- .030	R0.125	✓		"	"
R1.15	+/- .030	R1.145	✓		Vern	GA-01
R1.46	+/- .030	R1.460	✓		"	"
R1.56	+/- .030	R1.5625	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.
1.06	+/- .030	1.060	✓		H-6	31006
ø0.190	+ .005 / - .001	ø0.193	✓		Vern	GA-01
R0.13	+/- .030	R0.125	✓		R-6	ref.
R1.75	+/- .030	R1.750	✓		"	"
R0.13	+/- .030	R0.125	✓		"	"
1.70	+/- .030	1.694	✓		H-6	31006
1.73	+/- .030	1.726	✓		"	"
1.75	+/- .030	1.751	✓		"	"
0.59	+/- .030	0.585	✓		Vern	GA-01

Measured by: JA
Date: 11/03/23

Audited by: 
Date: 11/03/23

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

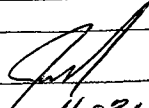
DART AEROSPACE LTD		Work Order: 66902
Description: HOUSING		Part Number: D4191-1
Inspection Dwg: D4191 Rev: PA6		Page 3 of 3

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/- .030	0.631	✓		Vern	GA-01
0.12	+/- .030	0.122	✓		D-6	GA-08
45°	+/- 1/2°	45°	✓		Angle protactor	ML-CBB
φ 0.200	+ .005 / - .001	φ 0.201	✓		Vern	GA-01
3.09	+/- .030	3.095	✓		"	"
0.44	+/- .030	0.444	✓		D-6	GA-08
1.55	+/- .030	1.565	✓		Vern	GA-01
0.13	+/- .030	0.128	✓		"	"
0.59	+/- .030	0.585	✓		"	"
φ 0.391	+ .006 / - .001	φ 0.393	✓		"	"
0.86 deep	+/- .030	0.869	✓		"	"
7/16-20 UNF 2B	N/A	7/16-20 UNF 2B	✓		bolt 7/16 UNF 2B	ref.

Measured by: B.A.
Date: 11/03/23

Audited by: 
Date: 11/03/23

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	